

SPLIT BLUE

Dart Aerospace Ltd.

Date: Thursday, 27/11/2008 2:23:32 PM  
User: Julie Dawson

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT CAP
Job Number	: 43801		
Estimate Number	: 10312		
P.O. Number	:	Part Number	: D2646
This Issue	: 27/11/2008 S.O. No. :	Drawing Number	: D2646 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11	Drawing Revision	: C
Previous Run	: 41435	Material	:
	Type : PURCHASED PARTS	Due Date	: 10/12/2008
Written By	:	Qty:	50 Um: Each
Checked & Approved By	: <u>JUD 08.11.27</u>		
Comment	: Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM Est Rev:H Changed Inserts 07-02-19 JLM est rev I changed inserts 07.06.11 EC		

76

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
<b>Comment:</b> PURCHASING Issue P/O: <u>7706</u> 1-Spin as per Dwg D2646 2-Material release note required		
2.0	D2646P	Aft Cap
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) AFT CAP		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
<b>Comment:</b> PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached		
4.0	QC6	DIMENSIONAL CHECK
<b>Comment:</b> DIMENSIONAL CHECK Inspect dimensions as per Dwg D2646		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1  1-Drill using DT8026 as per Dwg D2646.		

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Machine Or Operation:

Description :

2-Open holes to .297 as per Dwg D2646.

3-Deburr

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9.0

QC5

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

INSERT

Batch:

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



16x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

F P 4

M-1

08/12/24

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

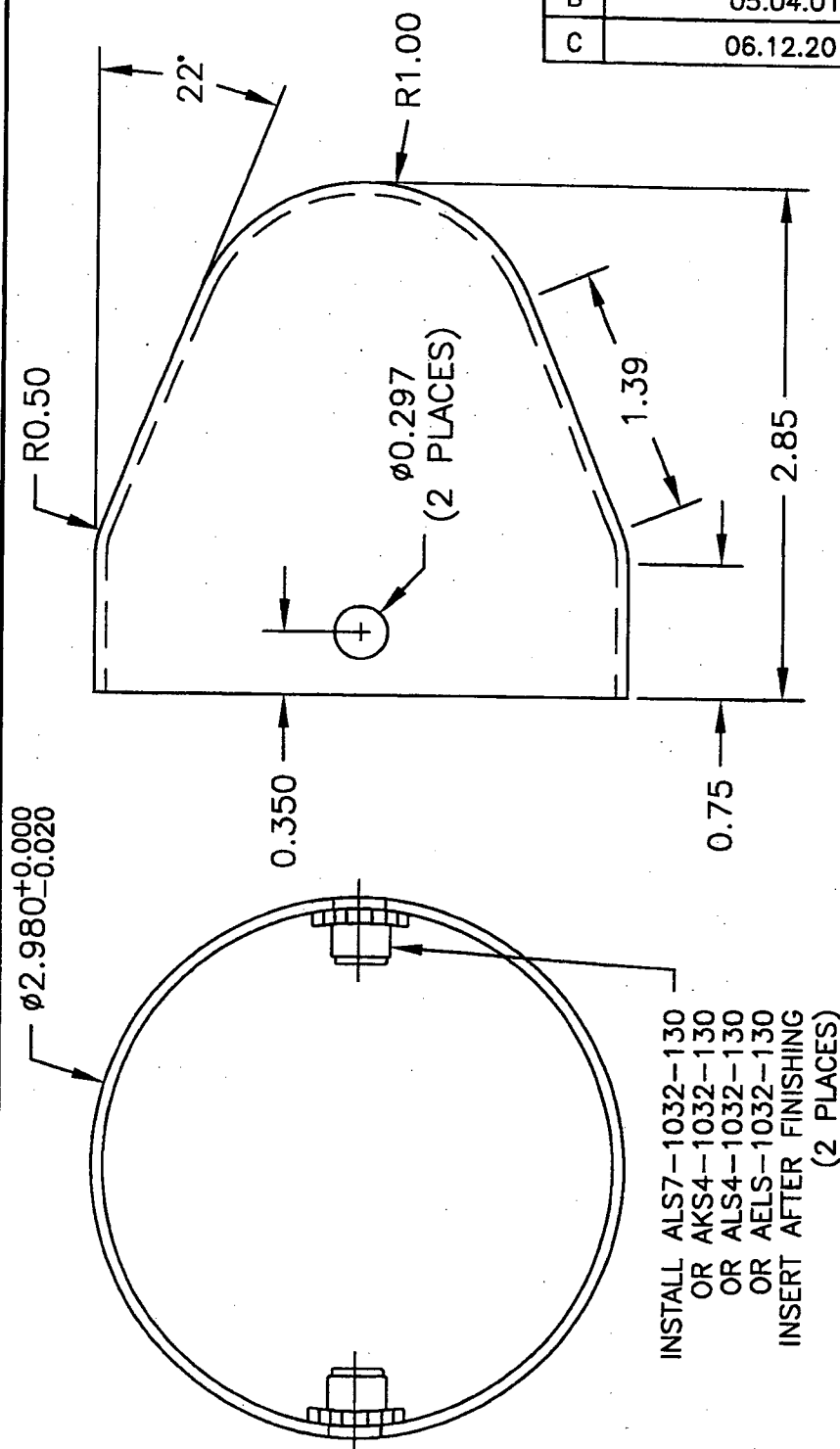
Job Completion



u 08-12-24

**DART**

DESIGN		DRAWN BY		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DS		PH			
CHECKED		APPROVED		DRAWING NO.	REV. C
				D2646	SHEET 1 OF 1
DATE				TITLE	SCALE
06.12.20				AFT CAP	1:1
A	97.03.25			NEW ISSUE	
B	05.04.01			CHANGE TO CLOSED INSERTS	
C	06.12.20			CHANGE TO OPEN ENDED INSERTS	



RELEASED

07.02.12

**D2646 AFT CAP**

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 43801

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ALCOA INDIUM PRODUCTS  
1480 Manheim Pike  
Lancaster Pa 17601

# Certification of Test Results

P/N 970200

PO 38C880

SOLD TO	SHIP TO	CERT NO	3000675396
		DATE	4/23/2007
		SKID NO	661031
		SKID WGT	9,885
		PAGE	1 OF 1

ORDER NO	LGS947	PO NO	43-62756			MILL FINISH NON ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO				
ALLOY	1100	TEMPER	0	FORM	COIL	
GAUGE	00300	WIDTH	48.0000	LENGTH	0.0000	

LOT: 334171 COIL: B01 DROP: 07T0187

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
*U718321	0.12	0.49	0.12	0.02	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI  
TAIL ULTIMATE STRENGTH 13.0 KSI  
HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI  
TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI  
HEAD ELONGATION (G.L. = 2 IN) 32 %  
TAIL ELONGATION (G.L. = 2 IN) 31.5 %

\* AS REPORTED BY SUPPLIER  
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:

ASME SB209 1100 C, AMS 4001H 1100 C,

ASTM B209-06 1100 O, AMS-QQ-A-250/1 1100 O

PAX CERTS: 714-736-4840

\*\* END OF CERTIFICATION \*\*

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples were representative of the material and the composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our products. Certification of test results shall not be reproduced except in full.

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Authorized By:

JEFF KREADY, LAB SUPERVISOR

Sold to: COPPER & BRASS SALES PO: 38C880 Part: Order No.: 376276

TR clerk signature: *C. J. [Signature]*



# Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7  
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

## INSPECTION REPORT

Date: 12/10/08

Customer: Dart Aerospace

Packing Slip: 36123

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By.
D2646P	50	142A	n/a	✓	<del>JS</del>

Notes:

PO# 7706

S  
02/12/12

Material Certification Attached: Yes